Trane Chiller Condenser tubesheet, waterboxes, end cover and division bar repair

DESCRIPTION:

Scale and deposits shall be removed from the condenser tubesheets, water boxes, associated end covers, and division bars. Natural corks will be inserted into all condenser tubes to prevent frosting of the tube ends during surface preparation.

All areas to be treated will be grit blasted to American Standard SP-10 with a minimum depth profile of 3 mils using an angular abrasive. The first corks will then be removed and new corks will be inserted flush into the tube ends and all surfaces to be coated will be thoroughly degreased.

If tubes are not flush with, and protrude form, the tubesheet, or there is pitting and erosion damage present, a rebuilding grade of ceramic metal will be required (Belzona or equivalent). The ceramic metal will be applied prior to the coating to rebuild damage and produce a flush surface between tubes. The coating will also be used to make a fillet on the condenser covers to produce a faired transition between the welded sections.

Two coats of Ceramic S-Metal (Belzona 1321 or equivalent) shall be applied to these surfaces to a minimum film thickness of 20 mils, observing proper over coating windows. After curing, each tube end will be chamfered and corks removed. All bolt holes will also be cleaned and chamfered.

Sufficient curing time will be allowed between coats and proper cure time will be allowed before chiller is reassembled and allowed to start. Work area will be kept clean. All chemicals, trash, and etc. will be removed from the work site daily and properly disposed of. Vendor will supply all materials and equipment to make needed repairs, labor for surface preparation and application of the protective system to rehabilitate Trane Reciprocating Chiller's condenser section tubesheets and end covers as per above stated scope.